

Work Order ID **76168*****76168***

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Monday, November 07, 2011 12:58:43 PM

Item ID: D3276-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Baffle Assembly RH
Start Date: 11/7/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/16/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: 11-11-07 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3276	Rev B

100 0.00
100 FLOW WATER JET
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3276 Dwg Rev: B Prog Rev: B 2-
6061.040 Debur if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control

120 0.00
120 QC8- Inspect parts - second check
QC Memo 0.00
Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76168

Monday, November 07, 2011 12:58:43 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					5			
Small Fab	Memo	0.00							
Small Fab	1-Deburr2-Roll as per Dwg D3276			SB 11/12/23					
140		0.00							
140	NC BRAKE					5			
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3276			SB 11/12/23					
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control				SB 11/12/23					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		11-12-23		5			
170 *170* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 1:30 FINISH TIME: 3:00 OVEN TEMPERATURE: 2:00	0.00 0.00							
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5			

SXØ M-11/12/28

5 BK-11-12-28

M119480

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
190	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3276								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									
210	Identify as per dwg & Stock Location: 175	0.00							
210									
Packaging	Memo	0.00							
Packaging									

Handwritten signature and date 11/12/29 with circled 5

Handwritten date 8/11/29

Handwritten circled 5

Handwritten 047

Handwritten date 11/12/29 with circled 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

CK 12/01/02

11-12-29
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Monday, November 07, 2011 12:58:47 PM

Work Order ID: 76168

76168

Parent Item: D3276-042

D3276-042

Parent Item Name: Baffle Assembly RH

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-12-06 JLM
IPP Rev:B Now on Waterjet 06-09-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3276-3 *D3276-3* Decal		Manufactured	No			110	Each	13.0000	1	4			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST045				13					
				56593				3					
				59694				10					
D2464 *D2464* 3/4 Seal		Manufactured	No			190	f	302.1000	2.25	9			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST404				302.1					
				61878				302.1					
M6061T6S-040 *M6061T6S 040* 6061-T6 .040 Sheet		Purchased	No			190	sf	65.4100	1.0205	4.296842			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				65.41					
				113004				7.5					
				117653				57.91					

Handwritten signature and date: 11/12/08

Handwritten signature and date: 11/12/08

Handwritten number: 11.25

Handwritten text: B11-11-10

Handwritten number: 117653

Handwritten circled number: 5

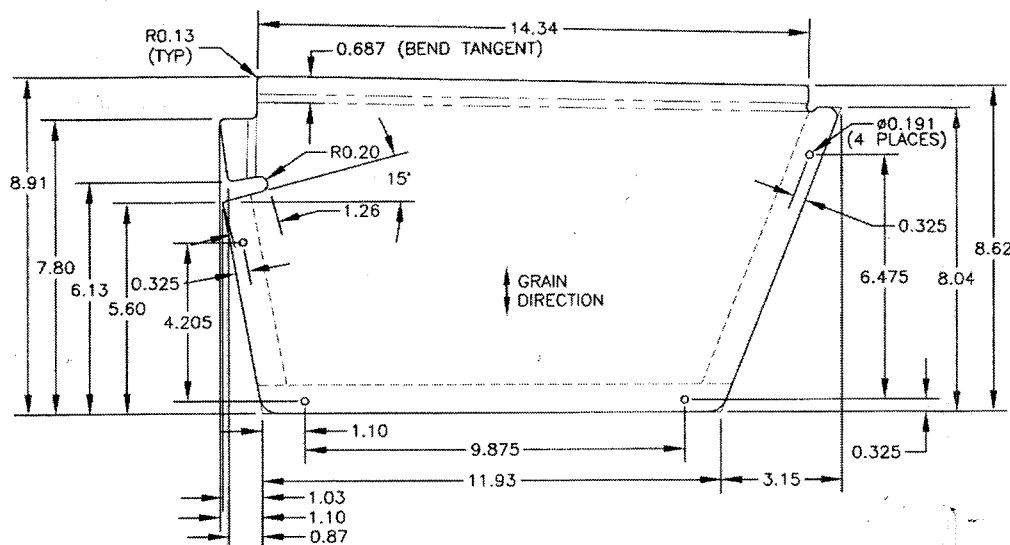
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

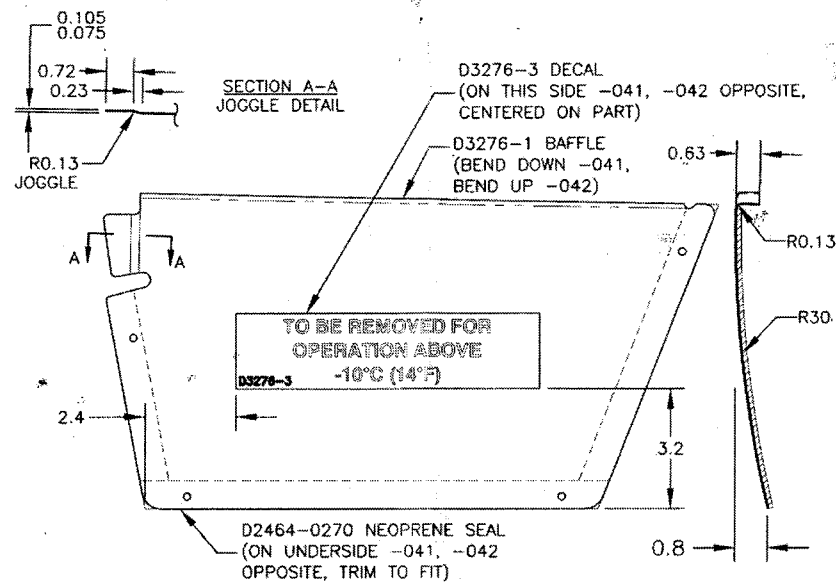
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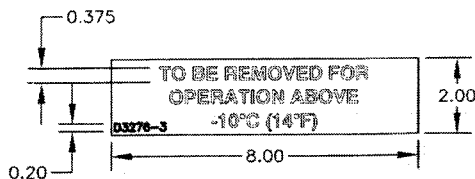
D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
R. 11-11-07
E. 11-11-07
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHIN THE
WORK ORDER
NO. 76668

RELEASED
05-02-07

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C, CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DRAWN BY
CHECKED	CP	APPROVED
DATE	05.01.25	TITLE
		BAFFLE ASSEMBLY
		SCALE
		1:3

DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

DRAWING NO. D3276
REV. B
SHEET 1 OF 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 76168
Description: BAFIE		Part Number: D3276-042
Inspection Dwg: D3276-2 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.34	$\pm .03$	14.34	X		T	1B01
8.62	$\pm .030$	8.630	X		T	
8.04	$\pm .030$	8.034	T		T	
$\phi .191$	$\pm .005 - .001$.193	X		V	1B02
.325	$\pm .010$.324	X		V	
11.93	$\pm .030$	11.93	X		T	
9.875	$\pm .010$	9.8	X		T	
5.60	$\pm .030$	5.60	X		T	
7.80	$\pm .030$	7.807	X		T	
8.91	$\pm .030$	8.911	X		T	
1.26	$\pm .030$	1.26	X		V	

Measured by: B	Audited by: S	Prototype Approval:
Date: 11-11-17	Date: 11/11/17	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	